

Work Order ID 56248

Wednesday, February 17, 2010 11:03:17 AM

Page 1

Item ID: D119-755-011

Accept

Revision ID:

Item Name: Crew Door Window, LH/RH

Start Date: 2/18/2010 Start Qty: 2.00

Required Date: 3/4/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3623

Rev A

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile & type labels per PPP D119-755-011 CHG 001

S 10/05/05

for CL 10/04/30

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10-4-30

SL (2X)

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

S 10/05/05

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



Work Order ID 56248

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Item ID:	D119-755-011	Accept		Setup	Start	
Revision ID:						
Item Name:	Crew Door Window, LH/RH				Stop	
Start Date:	2/18/2010	Start Qty:	2.00			
Required Date:	3/4/2010	Req'd Qty:	2.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-755-011								
	Location: <u>23</u>								
	PPP Rev: <u>A</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10-5-3 SP (24)

10/05/04

10-5-04
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 56248

Parent Item: D119-755-011

Parent Item Name: Crew Door Window, LH/RH

Comments: IPP Rev. A New Issue 7/04/2007 DL

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2126 Manufactured No 110 f 170.1702 14.9116



Seal

(D2126-085).

8 cut to 85.00" per dwg
r

L measure Sidew/20 x 2

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48285

170.1702

170.1702

110

Each

0.0000

2.0000

D3623-1



Window

2x

B6247 10-4-30sf

(2x)

3561-1

Seal insert tool

qty 1 per kit

Batch: B56109

10-4-30

sf (2x)

10.04.30

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D119-755

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3.2 Installation of D119-755-014 Bubble Window Kit

The Dart D119-755-014 Bubble Window Kit installs in the RH crew door of the A119/AW119MKII aircraft and should be installed as follows:

- 3.2.1 Remove RH crew door (109-0360-01-164 or equivalent) from the aircraft per the Aircraft Maintenance Manual.
- 3.2.2 Remove the existing window per the Aircraft Maintenance Manual or applicable instructions.
- 3.2.3 Install the D3624-2 Bubble Window in the doorframe using D2126-0850 Seal as shown in Figure 1. Before actually installing the window, verify that there is at least 0.30" (7.6mm) of overlap between the window and the door frame along the straight edges of the window and at least 0.12" (3.0mm) of overlap along the radius of the corners. The recommended procedure is to install the seal onto the door and then to install the window into the seal. Trim the ends of the seal as required. Seal ends should meet at the 6 o'clock position with a maximum gap of 0.125" (3.2mm). If a gap exists, it should be filled with Proseal or PRC. The included D3561-1 Seal Insert Tool can be used to assist in working the seal around the window. If necessary, it is acceptable to trim the window to improve the fit as long as the minimum overlap values are maintained.
- 3.2.4 Reinstall modified crew door on the aircraft per the Aircraft Maintenance Manual. Verify proper closing and sealing of the door.
- 3.2.5 Note: To increase downward viewing clarity, it is acceptable to cut a small section from the bubble window on its downward side. The cut-out can be a maximum of 5.25" wide x 13.50" long (133mm x 343mm), measured along the profile of the bubble window. The corners of the cut-out must have a minimum radius of 2" (50mm). The cut-out should be located within 1.0" to 1.5" (25mm to 38mm) of the bubble flange. The actual shape of the cutout can vary as desired, as long as the overall dimensions are within the specified limits. See Figure 2 for reference.

4.0 WEIGHT AND BALANCE

The following are the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-755-011	3.5 lb	±27.6 in	±97 in-lb	63 in	220 in-lb
Crew Door Window Kit, LH / RH	1.6 kg	±0.70 m	±1.12 m-kG	1.60 m	2.6 m-kG
D119-755-014	4.5 lb	+31.6 in	+142 in-lb	63 in	284 in-lb
Bubble Window Kit, RH	2.0 kg	+0.80 m	+1.60 m-kG	1.60 m	2.6 m-kG

5.0 PARTS LIST

Qty	Part Number	Description
X	D119-755-011	CREW DOOR WINDOW KIT (FITS LH & RH)
X	D119-755-014	BUBBLE WINDOW KIT, RH
1	D2126-0850	SEAL
1	D3623-1	WINDOW
1	D3624-2	BUBBLE WINDOW
1	D3561-1	SEAL INSERT TOOL

* Not part of the -011/-014 installations, tool only

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Revision: **B**

Date: 08.05.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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